

Date: Thursday, 6/7/2007 3:28:25 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 32848	
Estimate Number : 10773	
P.O. Number : <i>N/A</i>	Part Number : D33481
This Issue : 6/7/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3348 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 32587	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/14/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature] 07.06.08</i>	
Comment : Est: A 05.02.09 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S12GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.0191 sf(s)/Unit Total: 0.3822 sf(s)

1010/1025/A21/6aA SHEET

(M1010S12GA) .105" THK

Batch: *M101094**ml 07 06 09**(20)*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3348

Dwg Rev: *3*Prog Rev: *3**ml 07 06 09**(20)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*ml 07 06 09*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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*2-06-11 (20)*

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

*[Signature] 07/06/14**(20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/06/28</u>	<u>6</u>	<u>1 piece was snap at the set-up out of tolerance</u>	<u>[Signature]</u> <u>Q51042</u>	<u>Scrap & destroy</u>	<u>SS</u> <u>07/06/28</u>	<u>[Signature]</u> <u>Q51042</u>	<u>[Signature]</u> <u>Q51042</u>	<u>[Signature]</u> <u>Q51042</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 32848

Part Number: D33481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3348

SB 07/06/20

19

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/07/05 (19)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SF 93

7/1/550

(19x)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RD 07/07/06

Job Completion



W 07/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

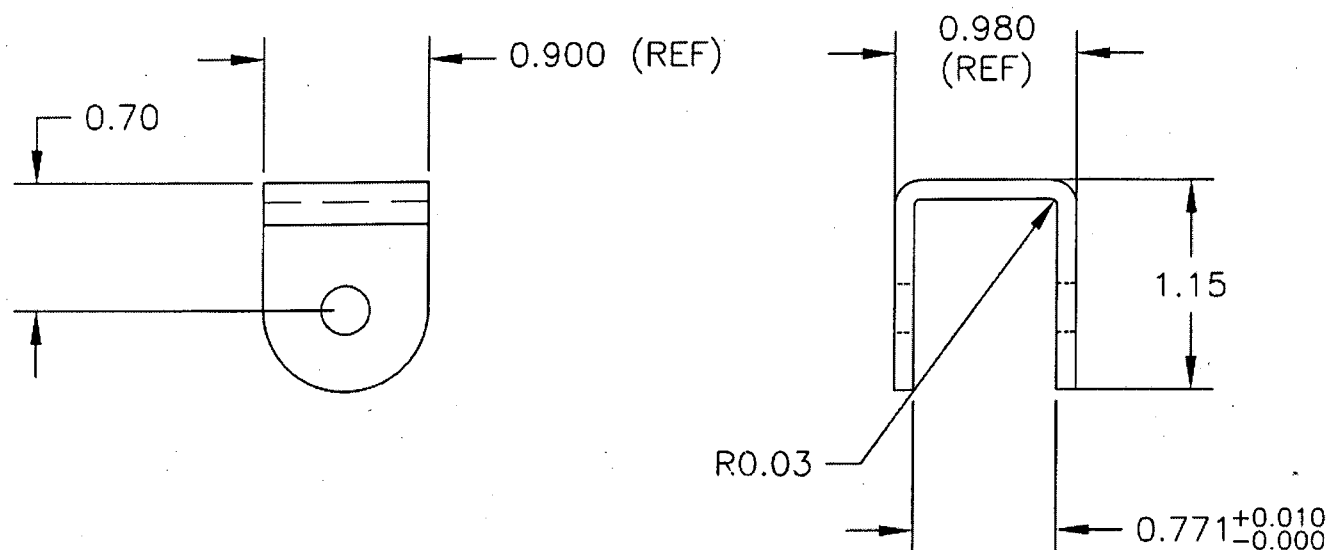
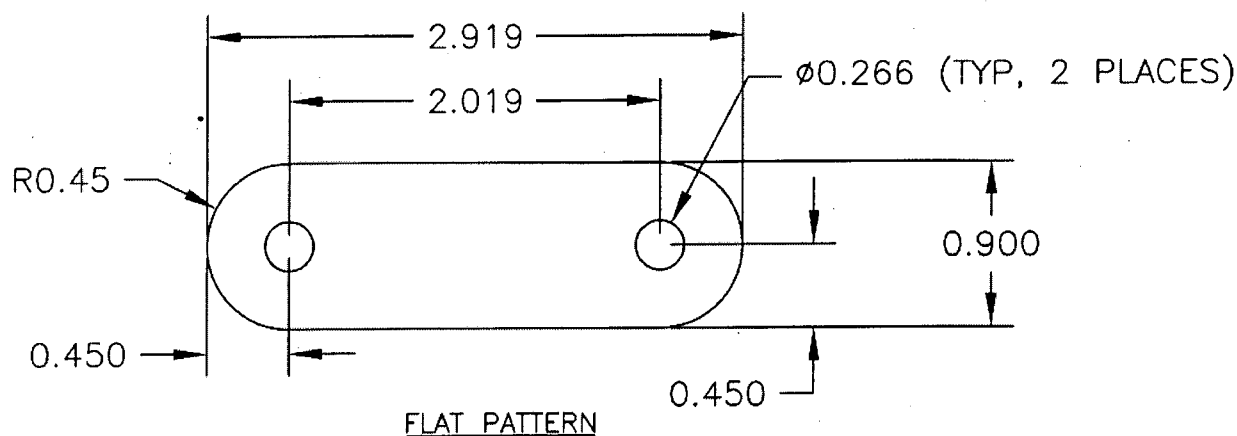
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3348	REV. B SHEET 1 OF 1
DATE 05.03.04		TITLE CLEVIS	SCALE 1:1
A	04.11.11	NEW ISSUE	
B	05.03.04	INSIDE RADIUS WAS R0.13, NOW R0.03	

RELEASED
05.03.05**BENDING DETAIL****D3348-1 CLEVIS**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,38W/44W/50W/60W/70W SERIES STEEL 12 GAUGE (0.105 THICK) (REF DART SPEC. M1010-S12GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 32848

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